

Work Order ID 58826

Wednesday, May 19, 2010 1:02:51 PM



Page 1

Item ID: D3637-3

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 5/19/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10-6-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3637

Rev B

100

0.00



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

2024 . 000

Memo

0.00

1-Cut as per Dwg D3637 Dwg Rev: B Prog Rev: B 02-
Deburr if necessary

RB 10-6-1

(12)

110

0.00



Memo

0.00

Quality Control

RB 10-6-1

120

0.00



Memo

0.00

Quality Control

8-10-6-02 / 10-6-02
(17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Brake NC

Operation
Description

NC BRAKE

Set Up/
Run Hours

0.00

Draw
Number

10914

Draw
Rev.

1

Plan
Code

10914

Accept
Qty

8

Reject
Qty

0

Reject
Number

10914

Insp.
Stamp

Brake NC

Form as per Dwg D3637

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

150



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1- drill holes as per dwg using DT8979 2- c'sink holes as per dwg 3-deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3637-3 PAR #: Fault Category: Small Fub NCR: Yes No DQA: Date: 1005-23
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: _____

NCR: 58826		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/05/17	130	I part broke at the bend. It looks like something was on part prior to bending process.	J J542	Scrap + destroy 100 replace	SN 10/09/14	S 10/05/14	J J542	J 1005-14

NOTE: Date & initial all entries

Work Order ID 58826

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Item ID: D3637-3

Revision ID:

Item Name: Bracket

Start Date: 5/19/2010 Start Qty: 8.00

Required Date: 5/26/2010 Req'd Qty: 8.00

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start			
	QC:	Date:	SPC (Y/N):	Date:	Stop				

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC5- Inspect part completeness to step on W/O QC Quality Control	0.00	<i>S. isolator</i>						
170 	Chemical Conversion Coat per QSI005 4.1 HandFinish Hand Finishing	0.00	<i>JK 10/09/10</i>					<i>XII q</i>	
180 	QC3- Inspect Part Finish QC Quality Control	0.00	<i>JK 10-9-10</i>						

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 58826

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Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 5/19/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

190



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: 244ASet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/9/10 SF 100

10/09/10 JF

10-9-10
11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 19, 2010 1:02:55 PM

Page 1

Work Order ID: 58826



Parent Item: D3637-3



Parent Item Name: Bracket

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:EC

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.050			No			100	sf	33.9947	0.134	1.7	1810-6-4	

2024-T3 .050 sheet

Location	Loc Qty	Loc Code
MAT22	33.9947	
111381	30.9	
112291	2.7	112291
113189	0.3947	

(12)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	58826
Description: Bracket	Part Number:	D3637-3
Inspection Dwg: D3637	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	IB	Audited by:	jl.	Prototype Approval:	N/A
Date:	10-6-1	Date:	10/06/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.12.01	New Issue	KJ/EC	

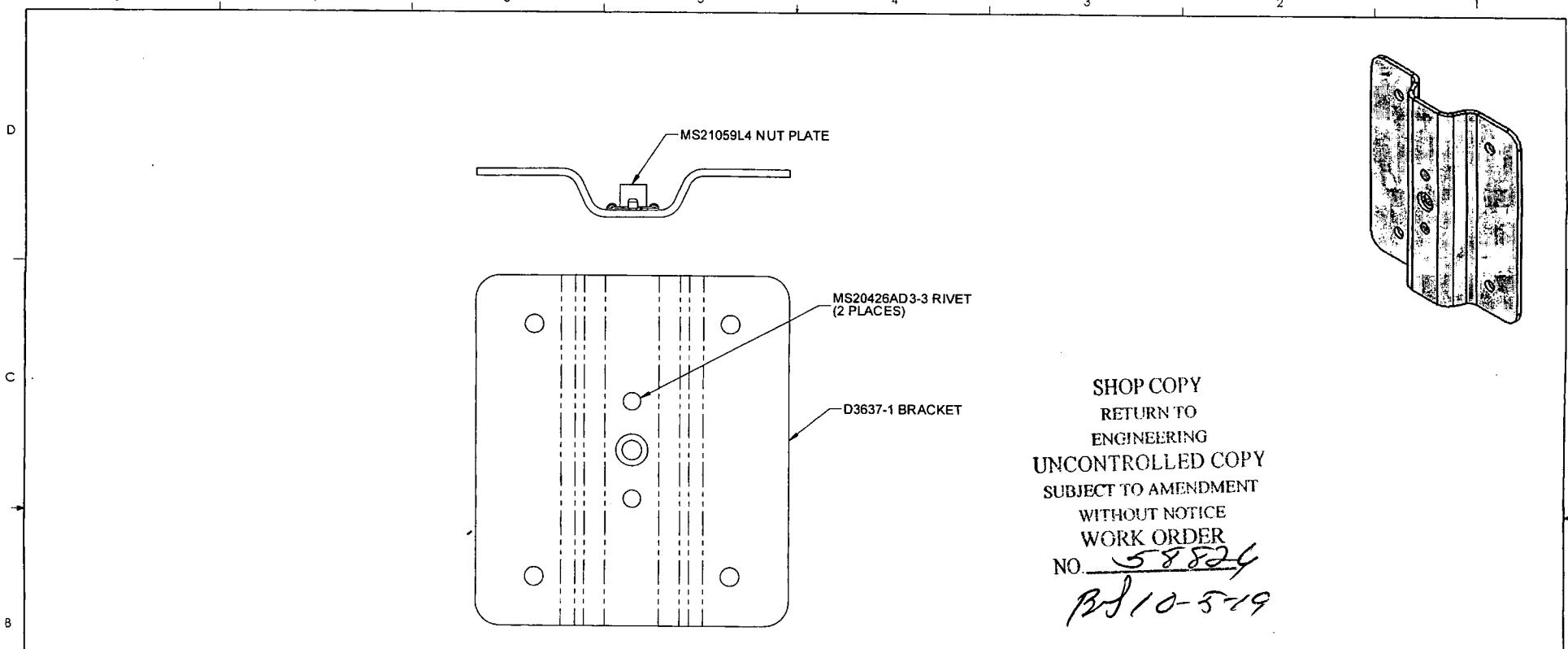
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58824
BS10-579

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: N/A
 4) UNITS: N/A
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.27 lbs

D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

11/20/03 10:00

B	FOR D3637-1, 1 15 WAS 1 30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE LTD	
DRAWN	<i>TS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>TS</i>	DRAWING NO. D3637	
MFG. APPR.	<i>TS</i>	REV. B	
APPROVED	<i>TS</i>	SHEET 1 OF 3	
DE APPR.	<i>TS</i>	TITLE	
DATE	07.12.18	SCALE	
		BRACKET	

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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

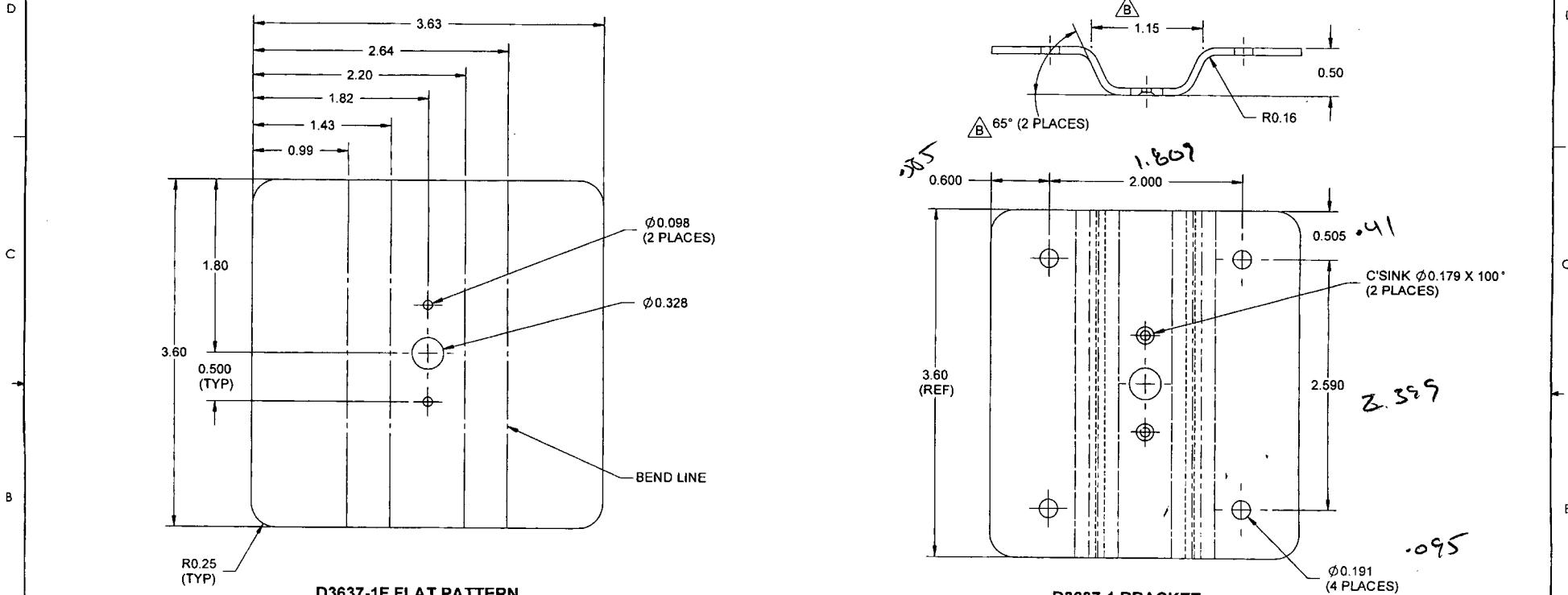
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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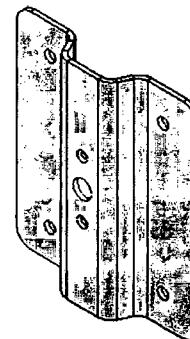
8 7 6 5 4 3 2 1

W/0 58826



A D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059
(REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs



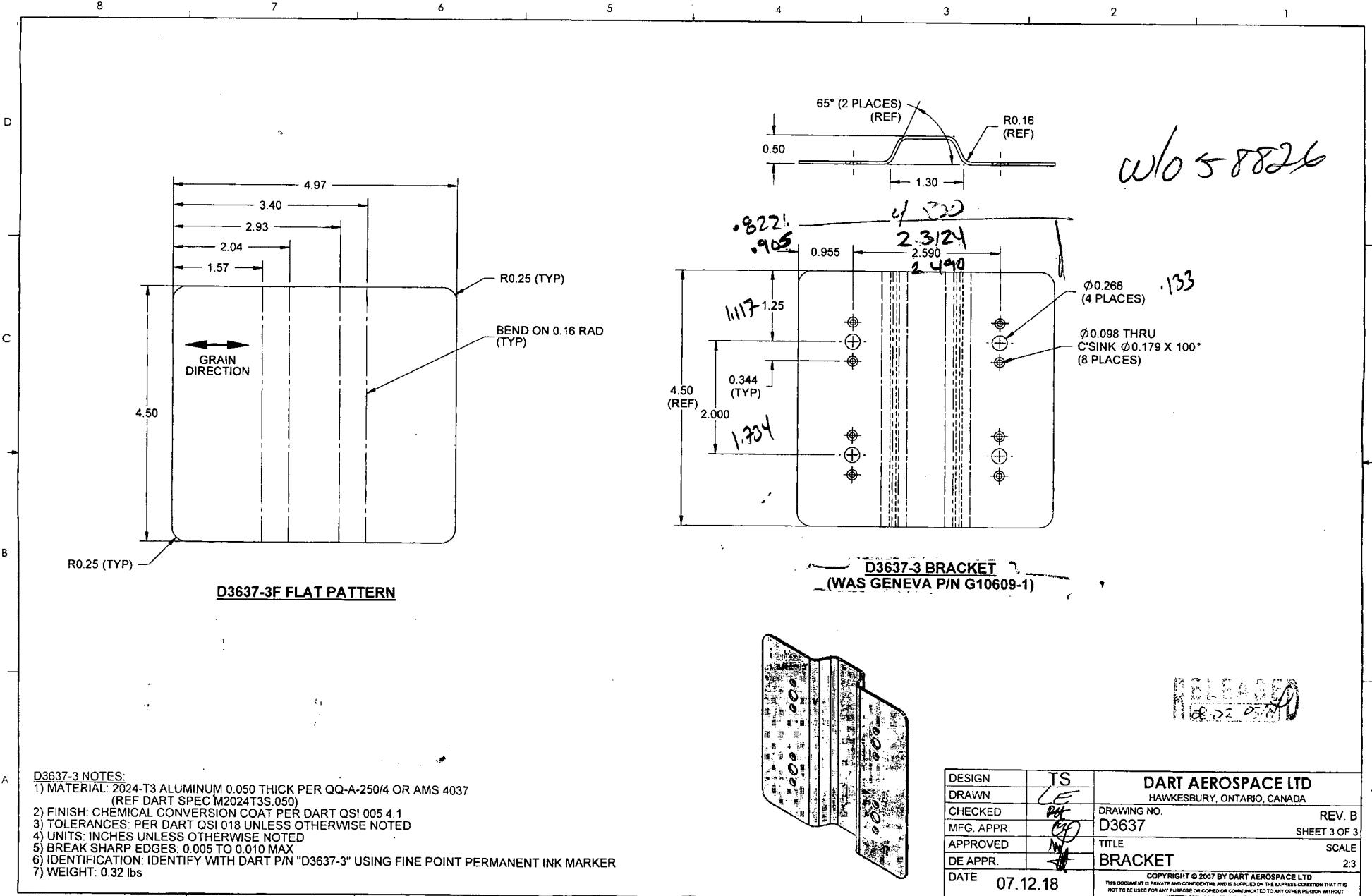
DESIGN	TS	DART AEROSPACE LTD
DRAWN	<i>LE</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>RL</i>	DRAWING NO. REV. B
MFG. APPR.	<i>LE</i>	D3637 SHEET 2 OF 3
APPROVED	<i>ML</i>	TITLE SCALE
DE APPR.	<i>ML</i>	BRACKET 1:1
DATE	07.12.18	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS THE CONFIDENTIAL PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

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